

Date: Friday, 5/25/2007 8:04:43 AM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	SPACEPOD DOOR LH		
Job Number	32555A					
Estimate Number	12598					
P.O. Number	N/A		Part Number	D31861M		
This Issue	5/25/2007	S.O. No.	N/A	Drawing Number	D3186 REV.D	
Prsht Rev.	NC			Project Number	N/A	
First Issue	N/A	Type	PURCHASED PARTS	Drawing Revision	D	
Previous Run	32296B01			Material	N/A	
Written By			Due Date	6/8/2007	Qty:	1 Um: Each
Checked & Approved By						
Comment	Est Rev:A New Issue 06-12-04 ec est rev D rv D dwg 07.03.07 ec					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING 
		Comment: PURCHASING 2852 Issue P/O: Description: D3186-1M Door Supplier: Delastek Conformity Certificate and Process sheet required
2.0	D31861	m Spacepod Door 
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Spacepod Door
3.0	PACKAGING 1	PACKAGING RESOURCE #1 
		Comment: PACKAGING RESOURCE #1 Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from Delastek is attached. 
4.0	QC6	DIMENSIONAL CHECK 
		Comment: DIMENSIONAL CHECK Inspect dimensions as per Dwg D3186 . Visual inspection. Check for void spot and pins. Ensure surface of doo is smooth, no dimples for drilling. 
5.0	PACKAGING 1	PACKAGING RESOURCE #1 
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location:

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action      Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:04:43 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD DOOR LH

Job Number: 32555A

Part Number: D31861M

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

RP 20109121 ①

Job Completion



6/27/09 21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

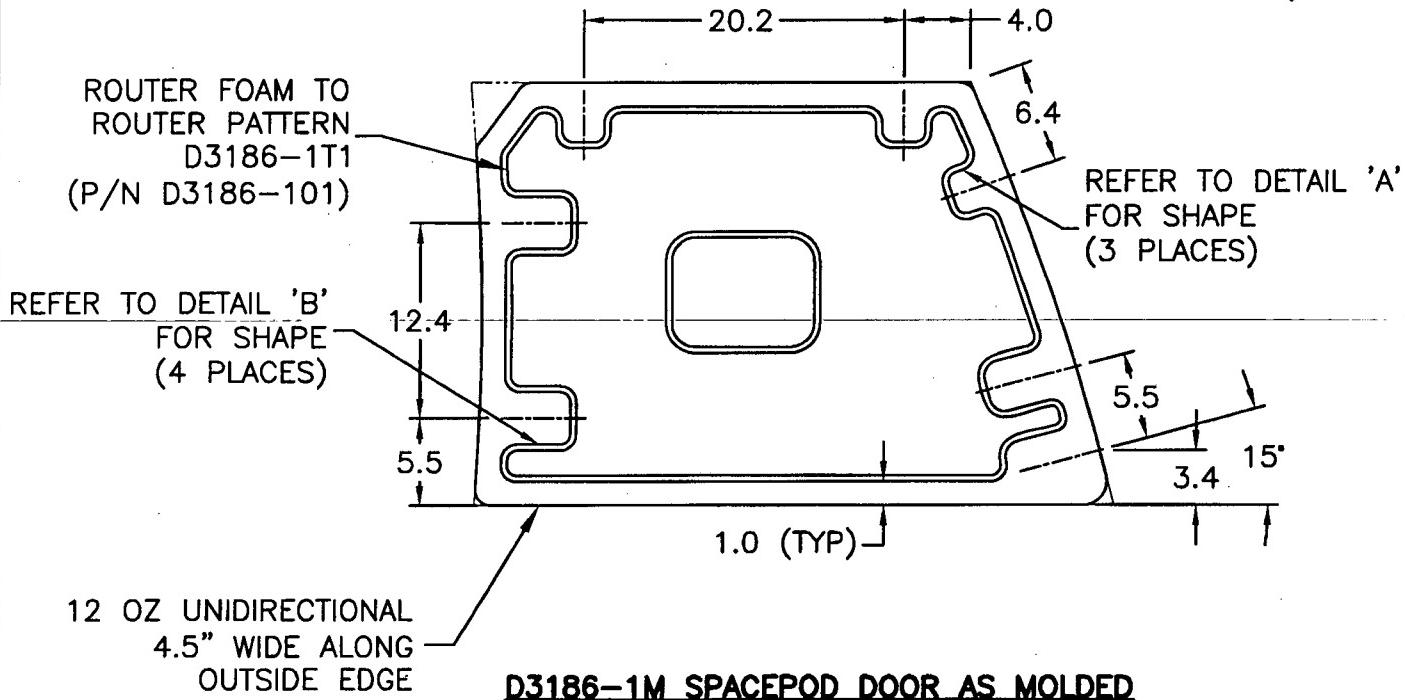
NOTE: Date & initial all entries

**DART**

DESIGN DS	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>B</i>	APPROVED <i>SH</i>	DRAWING NO. D3186	REV. D	SHEET 1 OF 5
DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS	
A	03.03.27	NEW ISSUE		
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED		
C	06.12.13	REMOVED D0600-XXX LABELS		
D	07.02.22	UPDATE DIMENSIONS		

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)  
 9 OZ SATIN (9 SQ FEET)  
 FOAM  
 9 OZ SATIN (9 SQ FEET)  
 12 OZ UNIDIRECTIONAL  
 9 OZ SATIN (9 SQ FEET)  
 RESIN (35-45% BY WEIGHT)  
 PEEL PLY

**RELEASED**07.02.27 *SH*NOTES:

- 1) USE MOLD DT8005 FOR DOOR LAYUP
  - 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
  - 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECCELL
  - 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
  - 5) LAMINATE PER DART QSI 006 4.0
  - 6) LAMINATION SCHEDULE PER THIS DRAWING
  - 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGBUILD GREY PRIMER 1144-S
  - 8) ALL DIMENSIONS ARE IN INCHES
  - 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO *32555A*

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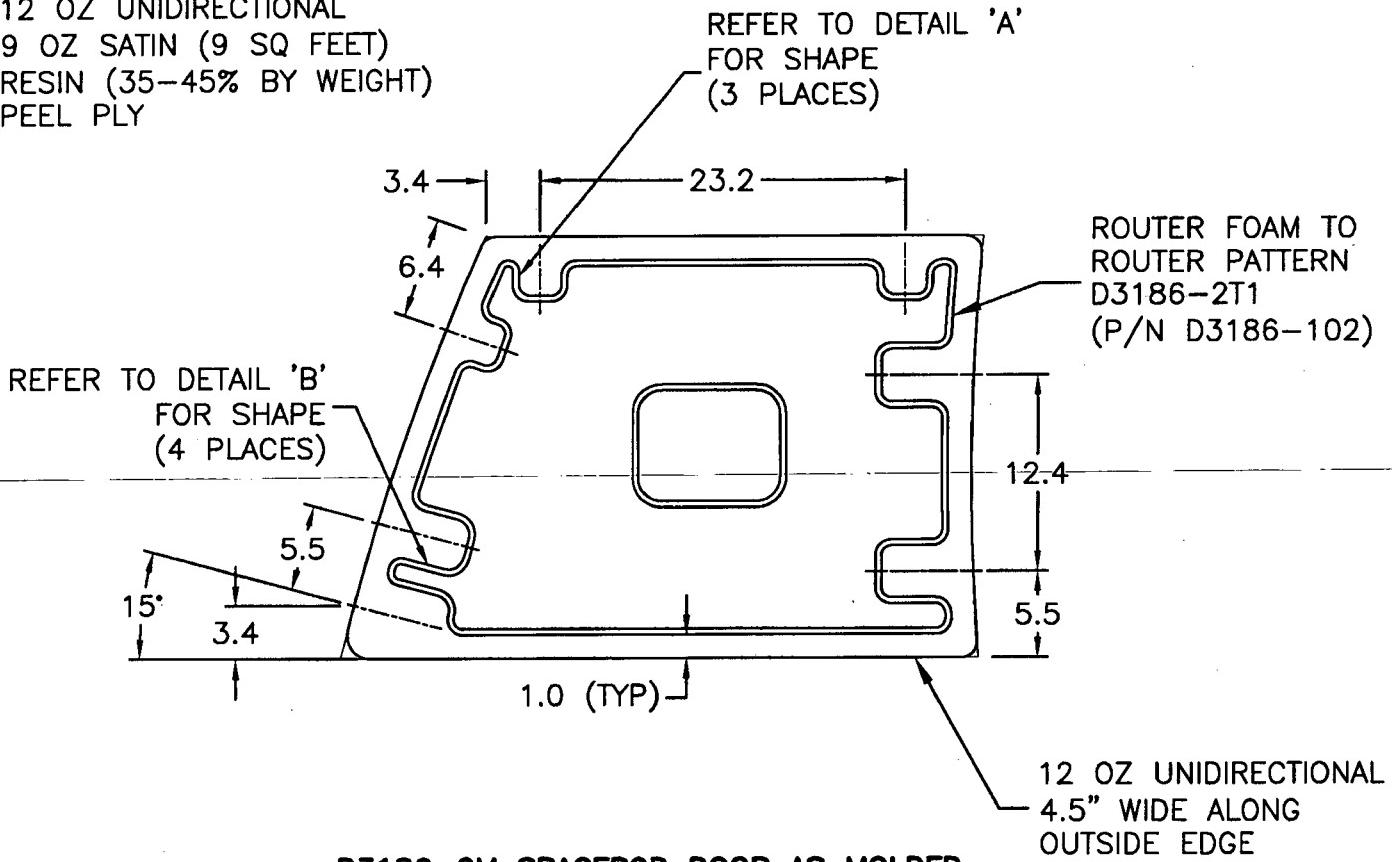
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CHECKED <i>BS</i>	APPROVED <i>CH</i>	DRAWING NO. D3186
DATE 07.02.22	TITLE	REV. D SHEET 2 OF 5 SCALE NTS SPACEPOD DOOR

## MAIN LAYUP

9 OZ SATIN (9 SQ FEET)  
9 OZ SATIN (9 SQ FEET)  
FOAM  
9 OZ SATIN (9 SQ FEET)  
12 OZ UNIDIRECTIONAL  
9 OZ SATIN (9 SQ FEET)  
RESIN (35-45% BY WEIGHT)  
PEEL PLY

RELEASED

07.02.27 *CH*

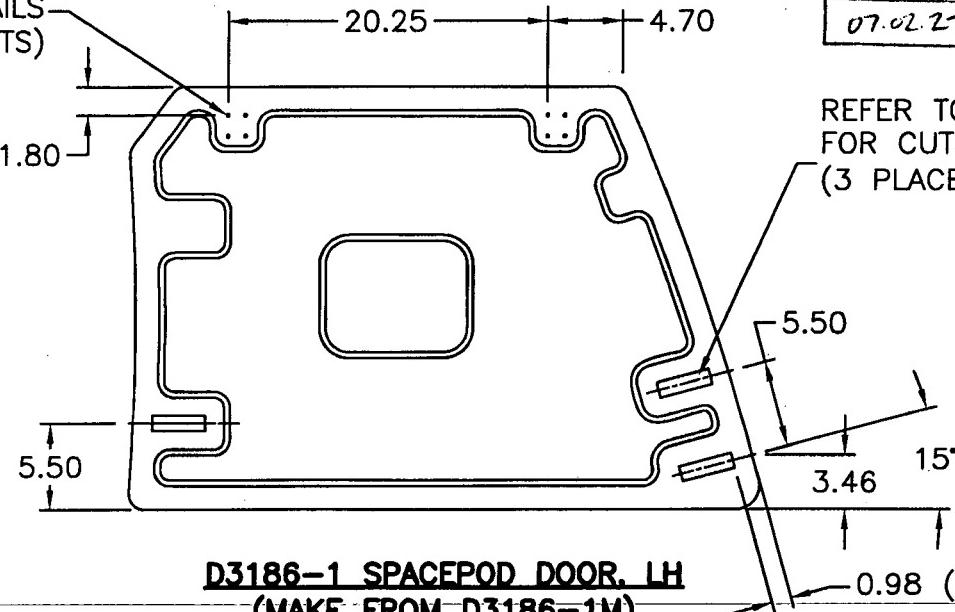
## NOTES:

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40      SHOP COPY
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECCELL      RETURN TO  
ENGINEERING
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
- 12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S<sub>NO.</sub> *30555A*      WITHOUT NOTICE  
WORK ORDER
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

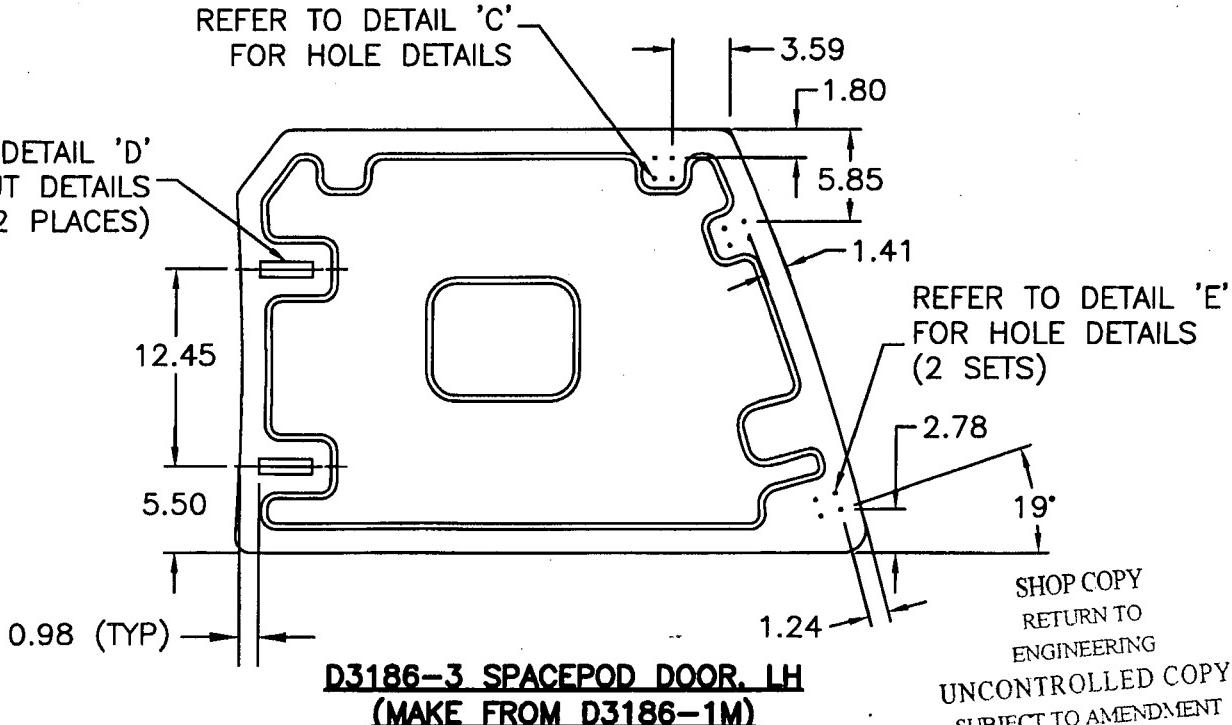
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CHECKED <i>b</i>	APPROVED <i>CH</i>	DRAWING NO. D3186	REV. D SHEET 3 OF 5
DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS

REFER TO DETAIL 'C'  
FOR HOLE DETAILS  
(2 SETS)

**RELEASED**07.02.27 *CH*

REFER TO DETAIL 'D'  
FOR CUTOUT DETAILS  
(2 PLACES)

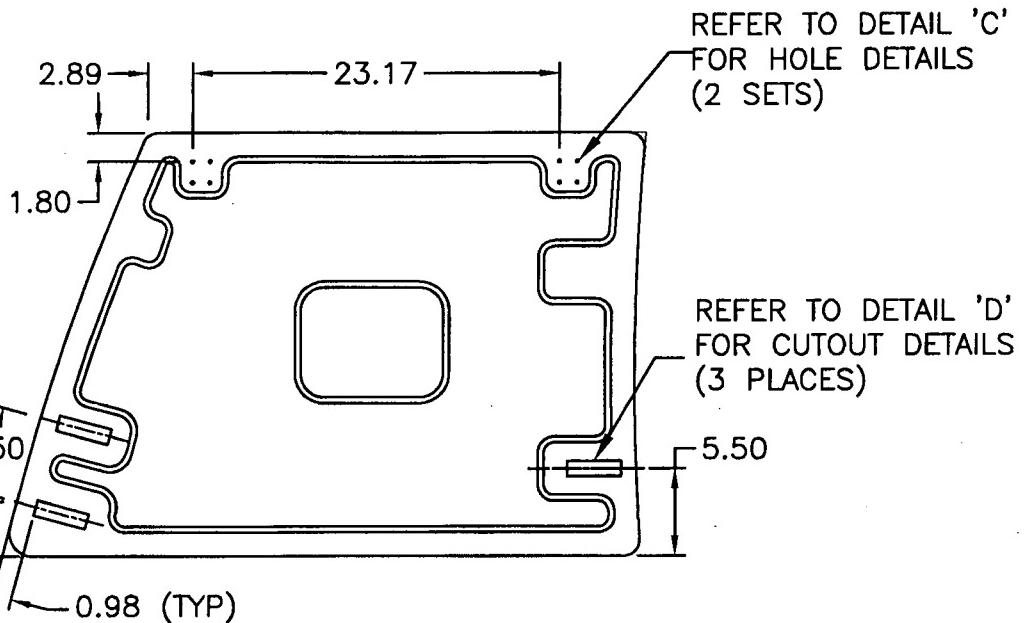
**NOTES:**

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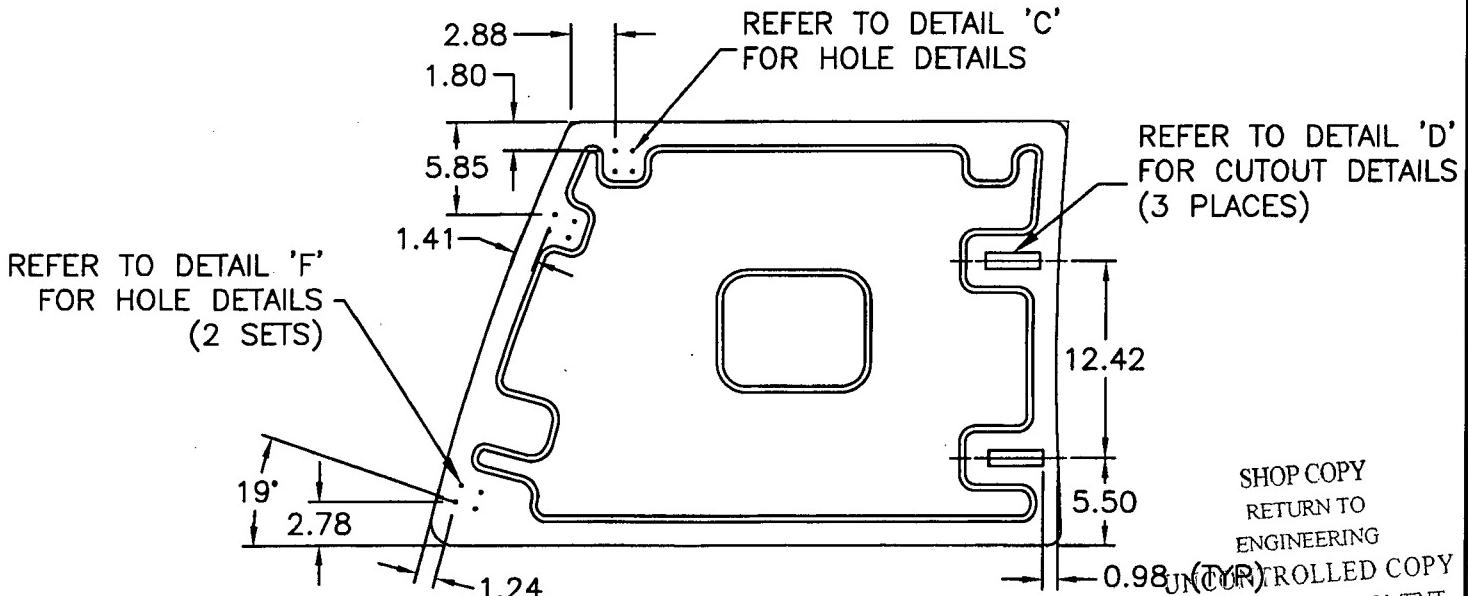
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CHECKED <i>B</i>	APPROVED <i>MM</i>	DRAWING NO. D3186	REV. D SHEET 4 OF 5
DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS

RELEASED

07-02-27 *MM*

D3186-2 SPACEPOD DOOR, RH  
(MAKE FROM D3186-2M)



D3186-4 SPACEPOD DOOR, RH  
(MAKE FROM D3186-2M)

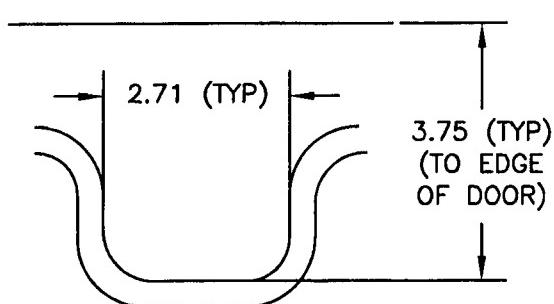
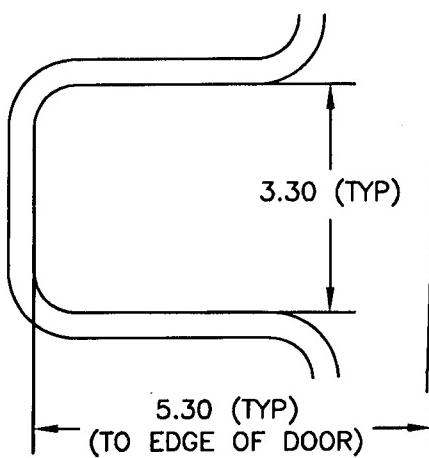
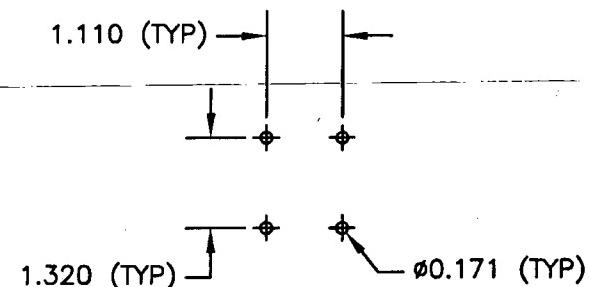
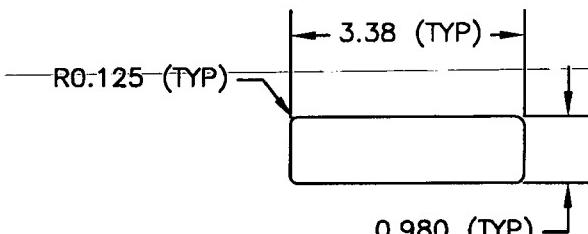
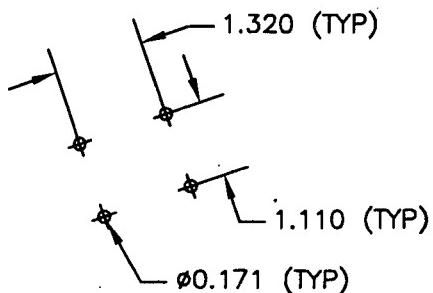
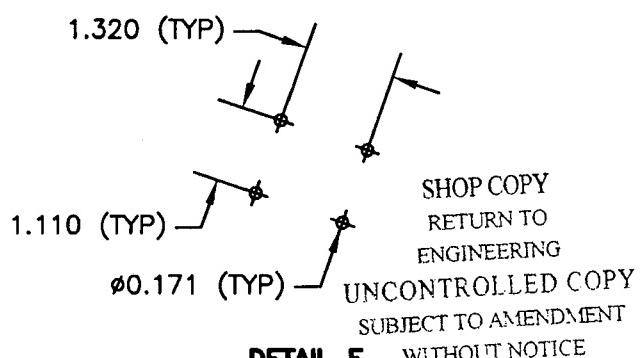
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DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS

**DETAIL A****DETAIL B****DETAIL C****DETAIL D****DETAIL E****NOTES:**

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